

Work Order ID 67927

Tuesday, April 05, 2011 9:58:41 AM



Page 1

Item ID: D3684-049

Accept



Setup Start



Revision ID:

Stop



Item Name: AFT LEG ASS'Y

Start Date: 4/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *[Signature]*

Date: 11-04-11 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

SB 11/04/11

(2)

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

SB 11/04/11

(2)

Small Fab

1-Use anti-seize compound Tectly 502c Class I, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67927

Tuesday, April 05, 2011 9:58:42 AM



Page 2

Item ID: D3684-049

Accept



Setup Start



Revision ID:

Stop



Item Name: AFT LEG ASS'Y

Start Date: 4/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 04 14 (2)

130

Identify as per dwg & Stock Location: 78

0.00



Packaging

Memo

0.00

Packaging

11/4/11 SP (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11 SP

ME
11-04-15

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 9:58:48 AM

Page 1

Work Order ID: 67927

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y



Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	41.0000	2	4			
Bolts													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				41					
					116924			41					
D3688-3 		Manufactured	No			110	Each	3.0000	1	2			
STUD													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				3					
					61371			3					
D3689-1 		Manufactured	No			110	Each	2.0000	1	2			
SLEEVE													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2					
					65346			2					
D3691-1 		Manufactured	No			110	Each	24.0000	1	2			
STUD													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				24					
					61370			13					
					62181			11					

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 9:58:49 AM

Page 2

Work Order ID: 67927

Parent Item: D3684-049



Parent Item Name: AFT LEG ASS'Y



Start Date: 4/4/2011



Required Date: 4/8/2011



Start Qty: 2.00

Required Qty: 2.00

D3692-1	Manufactured	No	110	Each	225.0000	4	8
							<u>SB 11/04/14</u>
SPACER							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	225			<u>8</u>
			51467	225			<u>2</u>
D3693-1	Manufactured	No		110	Each	22.0000	1
							<u>SB 11/04/14</u>
Rod End Bearing							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			GA	22			<u>2</u>
			50734	22			<u>4</u>
MS21043-3	Purchased	No		110	Each	1,072.000	2
							<u>SB 11/04/14</u>
Nut							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FG	80			
			103691	80			
			FP-B	16			
			112314	16			
			ST301	976			<u>4</u>
			112314	976			<u>2</u>
NAS509-12C	Purchased	No		110	Each	28.0000	1
							<u>SB 11/04/14</u>
Nuts							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST280	28			<u>2</u>
			112453	28			

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, April 05, 2011 9:58:49 AM

Page 3

Work Order ID: 67927

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y



Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

NAS509L12C

Purchased

No

110

Each

33.0000

1

2



Nuts



SB 11/04/14

Location

Loc Qty

Loc Code

ST280

33

112314

23

112828

10

2

Tuesday, April 05, 2011 9:58:49 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

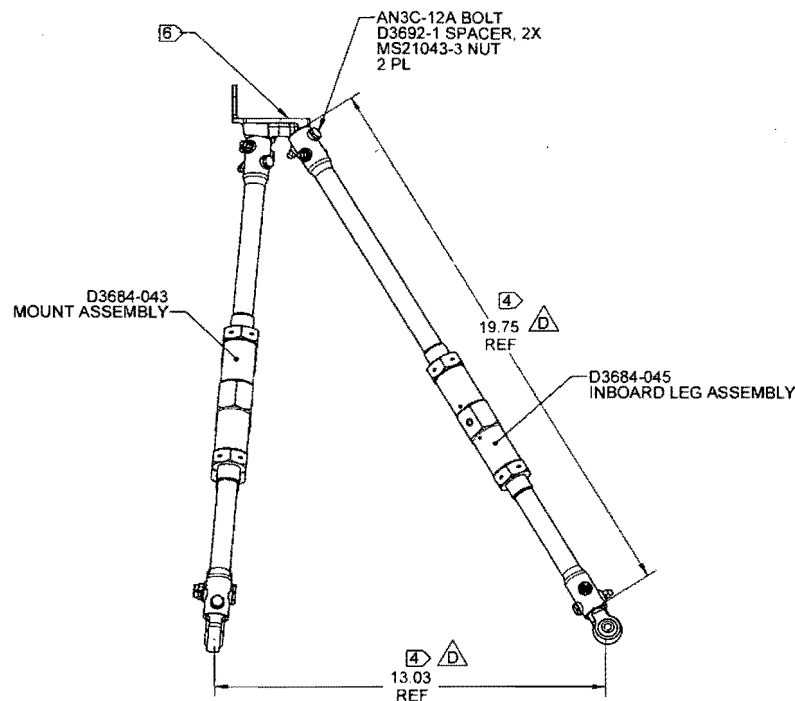
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT



D3684-041 TRIPOD MOUNT ASSY 7

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs
- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67927
pl 11-045

RELEASED
2010-03-15
mp

D	13.03 WAS 13.10 (ZN B5-1); 19.75 WAS 19.87 (ZN C4-1); 19.40 WAS 19.52 (ZN C6-2); 17.15 WAS 17.27 (ZN C4-2); 19.85 WAS 20.24 (ZN B5-2); 20.95 WAS 21.05 (ZN C5-3); 20.62 WAS 20.74 (ZN C5-4); 18.37 WAS 18.49 (ZN C6-5)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D8-1, A8-2, D8-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C5-4); 6.95 WAS 6.88 (ZND5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.03		
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REV. D		SHEET 1 OF 5	
		SCALE	
		NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

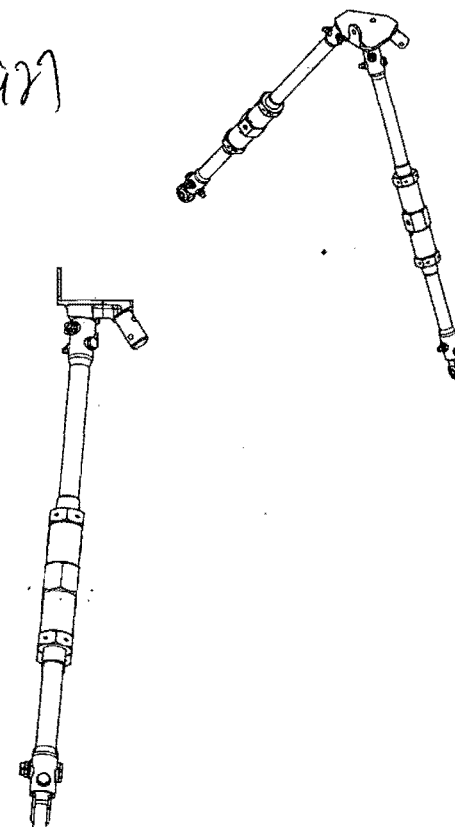
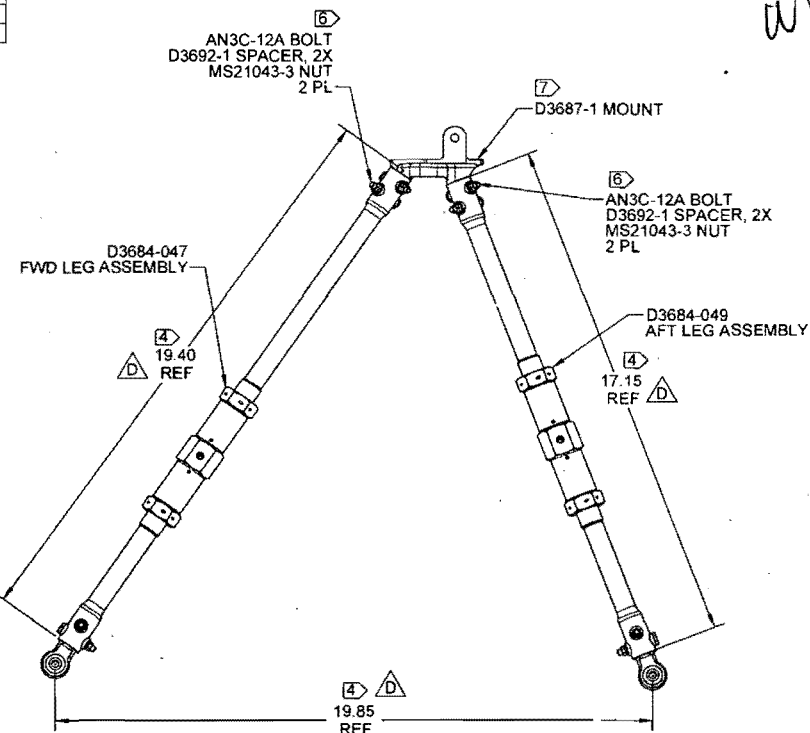
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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MFG. APPR.		D3684	SHEET 2 OF 5
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DE APPR.		TRIPOD MOUNT ASSY	NTS
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RELEASE
R 2010-03-15
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

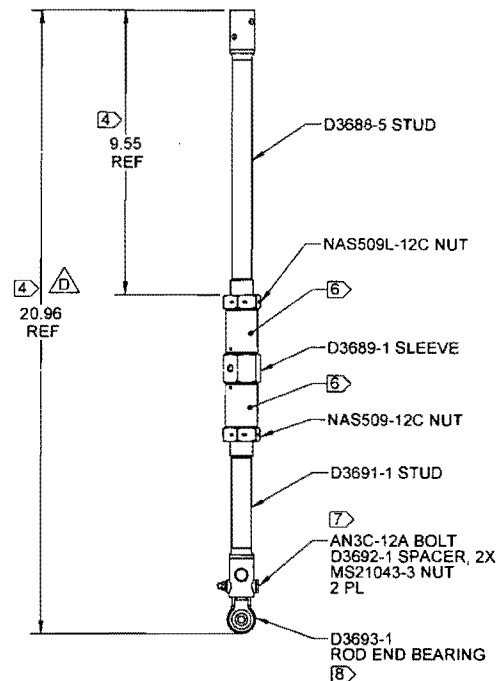
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT






D3684-045 INBOARD LEG ASSEMBLY



RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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MFG. APPR.		D3684	SHEET 3 OF 5
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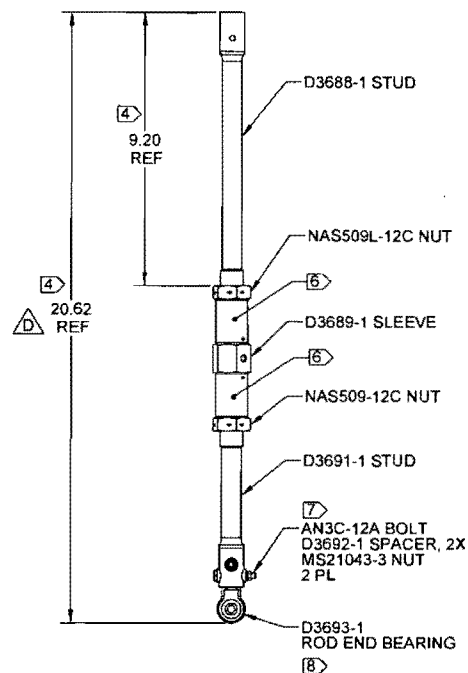
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NOTE: Date & initial all entries



ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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MFG. APPR.			D3684	SHEET 4 OF 5
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2010-03-15

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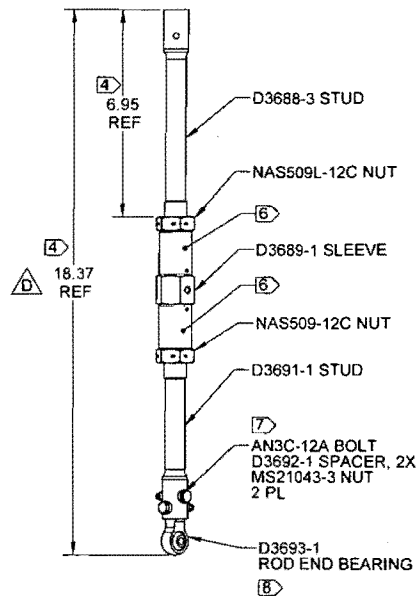
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

NOTES:

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- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3684	REV. D
MFG APPR.	<i>[Signature]</i>		SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE TRIPOD MOUNT ASSY	SCALE NTS
DE APPR.	<i>[Signature]</i>		
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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